

November-15-11 8:10:20 AM

76465

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Center Divider

Start Date: 15/11/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/15

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N):

Date:

Stop ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76465

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 15/11/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Dáte:** _____ **Tooling:** _____ **Date:** _____

Run Start: *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

Bend as per dwg D3251

140

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.00

QC

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

Memo

0.00

HandFinish

Hand Finishing

W/O: 76465		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3251-041 PAR #: _____ Fault Category: Small Fab NCR: (Yes) No DQA: Aut Date: 12/06/12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/16/12

NCR: 12-1481		WORK ORDER NON-CONFORMANCE (NCR) 18.10 ⁹						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/31	130	1 part crack at the band R.C. Puxes	S 057042 12/5/31	Scrap + destroy no replace	SB 12/05/31	S 12/5/31	S 12/05/31 057042	S 12/5/31

NOTE: Date & initial all entries

November-15-11 8:10:20 AM

76465

Page 3

N900040100

Setup .Start *NS1*

Stop ***NS2***

4

4

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

160

Quality Control

170

Small Fab

Assemble as per dwg D3251

180

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76465

76465

Page 4

November-15-11 8:10:20 AM

Item ID: D3251-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Center Divider
Start Date: 15/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 29/11/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating <i>M121279</i>	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: <i>3:40</i> FINISH TIME: <i>32:00</i>	0.00 0.00				<i>3X</i>	<i>Ø</i>		<i>Mf</i> <i>12/06/04</i>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>3</i>	<i>Ø</i>		<i>12-6-5</i>
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <i>511/5</i> Memo	0.00 0.00				<i>3</i>		<i>545</i>	<i>12/06/05</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76465***76465***

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November-15-11 8:10:20 AM

Item ID: D3251-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Center Divider
Start Date: 15/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 29/11/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/6/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 76465

76465

Parent Item: D3251-041

D3251-041

Parent Item Name: Center Divider

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3251-1 no longer made in-house
IPP C 08.11.13 in-house EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20470AD4-5 *MS20470AD4-5* Rivet, Universal Head		Purchased	No			100	Each	2,424.000	18	72			
**													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST319 2424													
116893 68													
118405 2356													
D3248-1 *D3248-1* Doubler		Manufactured	No			170	Each	15.0000	2	8			
**													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST044 15													
66195 3													
66555 12													
M2024T3S.063 *M2024T3S 063* 2024-T3 .063 sheet		Purchased	No			170	sf	33.5000	3.41	14.35789			
**													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
MAT022 33.5													
117392 33.5													

Handwritten notes and signatures:
 12/05/31
 234
 12/05/31
 33
 12-5-32
 119916

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76465
Description: Center Divider (Dual Battery Rack)		Part Number: D3251-1
Inspection Dwg: D3251	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.567	+/-0.010	21.567	1		T	
1.250	+/-0.010	1.255	2		U	
5.16	+/-0.030	5.163	2		U	
1.079	+/-0.010	1.080	1		U	
R0.19	+/-0.030	.19	2		R.G.	
4.15	+/-0.030	4.15	2		U	
2.75	+/-0.030	2.753	2		U	
0.300	+/-0.010	.304	1		U	
3.71	+/-0.030	3.713	2		U	
1.250	+/-0.010	1.248	2			
2.97	+/-0.030	2.97	2			
10.81	+/-0.030	10.808	1			
9.90	+/-0.030	9.90	2			
18.595	+/-0.010	18.595	1			
0.983	+/-0.010	.990	1			
Ø0.257	+0.005/-0.000	.258	2		U	
23.289	+/-0.010	23.289	2		T	
11.000	+/-0.010	11.006	2			
Ø0.128	+0.005/-0.000	.131	1		U	
5.403	+/-0.010	5.403	2			
0.987	+/-0.010	.990	1			
11.77	+/-0.030	11.777	2			
4.499	+/-0.010	4.496	1			
1.375	+/-0.010	1.375	2			
2.750	+/-0.010	2.748	2			
Ø1.500	+0.005/-0.000	1.503	2		U	
Ø0.501	+0.005/-0.000	.501			U	
21.056	+/-0.010	21.056	2		T	
18.93	+/-0.030	18.93	2		U	
Ø0.125	+0.005/-0.000	.125	2		U	
Ø0.098	+0.005/-0.000	.101	2		U	
R0.30	+/-0.030	.30	1		R.G.	
0.300	+/-0.010	.300	2		U	
0.063	+/-0.010	.064	2		U	
Grain along 21.056	N/A	21.056	X		T	

Measured by: B	Audited by: [Signature]	Prototype Approval: N/A
Date: 12-5-30	Date: 12-05-30	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

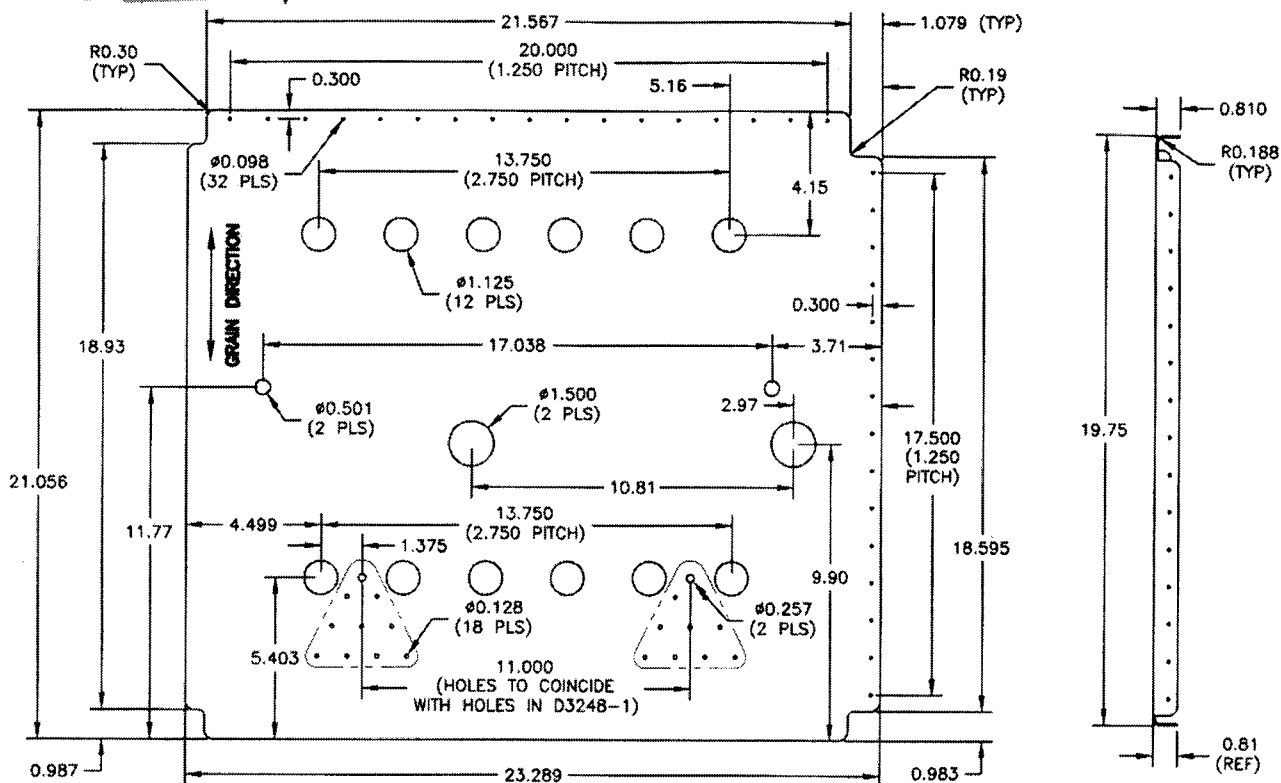
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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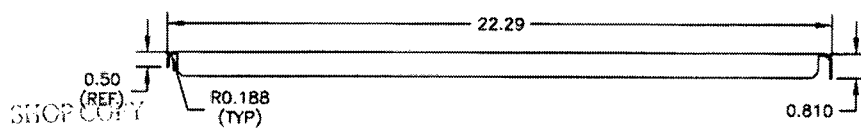


DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED AP	APPROVED JH	DRAWING NO. D3251	REV. A SHEET 1 OF 1
DATE 04.04.06	TITLE CENTRE DIVIDER (DUAL BATTERY RACK) 1:6		SCALE
A	04.04.06	NEW ISSUE	

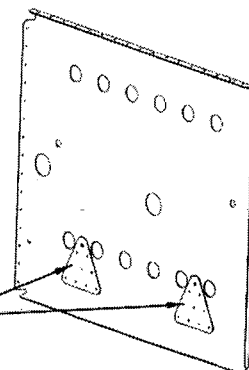
RELEASED
04.05.04



FLAT PATTERN



D3251-1 BEND DETAIL



INSTALL D3248-1
USING M520470A4-5
RIVETS

D3251-041

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

- NO. 76465
- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries